

July Aug 5

Work Order ID 72646



Wednesday, August 03, 2011 2:32:19 PM

Item ID: D4334-7

Accept



Setup Start



Revision ID:

Stop



Item Name: Fairing

Start Date: 8/3/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 8/4/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

[Signature]

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4334

A

100

0.00



HandThermo

Hand Finishing Thermoforming

Memo

1-Cut Sheet to required Blank size

0.00

x1

Dh
11/08/09

105

0.00



HandThermo

Hand Finishing Thermoforming

Dry Material

Memo

Dry Sheet as per QSI022 POLYCARBONATE

Temp: 240°F

Time IN: 4:30 pm

Time OUT: 2:00 am

0.00

x1

Dh
11/08/09

Dh 11/08/08
Dh 11/08/09

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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110

0.00



Thermoform

Memo

0.00

Thermoforming Machine

1-Machine Set-Up
2-Pre-heat Tool to required temp.
3-Thermoform as per Dwg and Folio #FTA106 using tool DT9717
Dwg Rev: A
Folio Rev: A

x1

Wb
11/08/09

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

Visually inspect part for proper formation and texture

x1

Wb
11/08/09

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

x1

B
11/08/09

Work Order ID 72646



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Accept



Setup Start



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Item Name: Fairing

Start Date: 8/3/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 8/4/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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140

0.00



HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Trim to finished dimensions as per Dwg

x1

Wh
11/08/09

150

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

Complete FAI document

x1

Wh
11/08/09

160

0.00



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

Sulostor

@

Work Order ID 72646

Wednesday, August 03, 2011 2:32:19 PM

Page 4

Item ID: D4334-7

Accept

Revision ID:

Item Name: Fairing

Start Date: 8/3/2011 Start Qty: 1.00

Required Date: 8/4/2011 Req'd Qty: 1.00

Reference:

Cust Item ID:



Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170  Packaging	Identify as per dwg & Stock Location: _____ Memo	0.00 0.00							
180  QC	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							
Packaging									
Quality Control									

11/9/09

CK 11/08/09

ME
11-08-09

Picklist Print

Wednesday, August 03, 2011 2:32:16 PM

Page 1

Work Order ID: 72646



Parent Item: D4334-7



Parent Item Name: Fairing

Start Date: 8/3/2011

Required Date: 8/4/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev. A New Issue 11/04/012 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04		Purchased	No			100	sf	1,285.115	3.46875	3.46875			



GE PLASTICS LEXAN SHEET

Location

MAT018

116236

Loc Qty

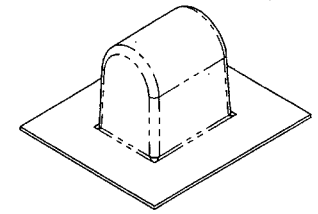
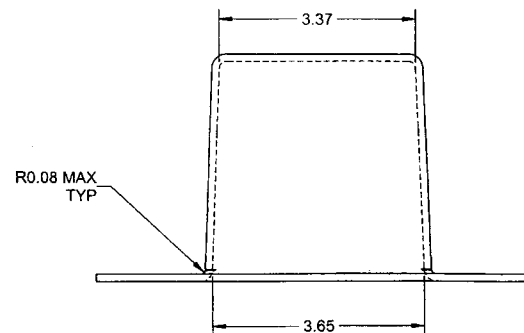
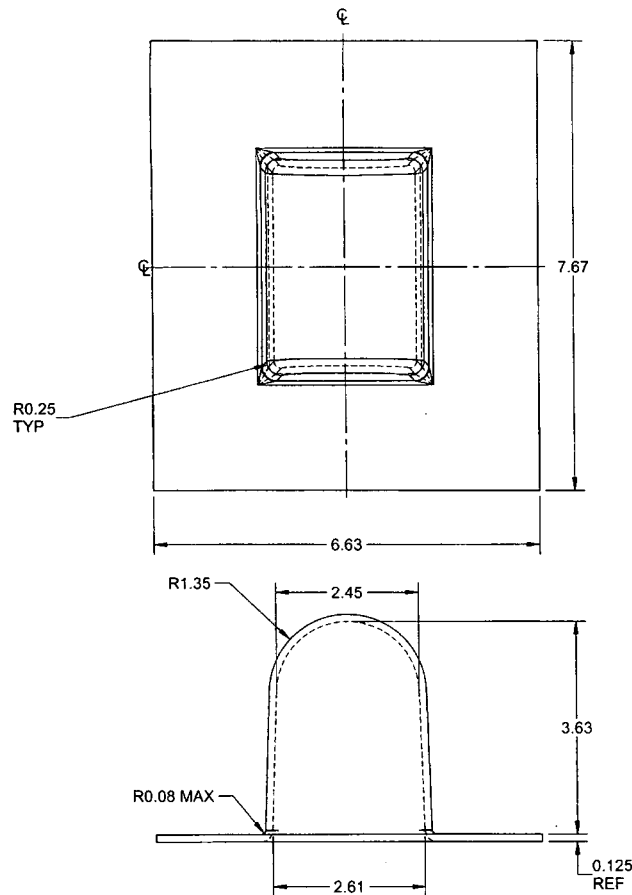
1285.115789

1285.11579

Loc Code

3.46875

11/08/09



D4334-7 FAIRING

RELEASED
2011-05-20

NOTES:

- 1) MATERIAL: F60029-GY3778 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE) . 0.125 THICK
REF DART SPEC MLEXS.125-F60029-04
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.34 lbs
- 8) THERMOFORM USING DT9758 MOULD

W/O 72046

DESIGN		DART AEROSPACE LTD	
DRAWN	<i>JS</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>BC</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>JS</i>	D4334	SHEET 7 OF 11
APPROVED	N/A	TITLE	SCALE
DE APPR.	N/A	BRACKET	NTS
DATE	11.04.18	COPYRIGHT © 2011 BY DART AEROSPACE LTD	
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DART AEROSPACE LTD		Work Order:	72646
Description: FAIRING.		Part Number:	D4334-7
Inspection Dwg: D4334-7 Rev: A.		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST
THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <i>N/A</i>				
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: <i>DL</i>	Date: 11/08/09
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TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
7.67"	± 0.1	7.65"	✓		TAPE DL-01	See Attached E-MARK.
6.63"	± 0.1	6.56"	✓		TAPE DL-01	
2.61"	± 0.1	2.71"	✓		VERN TH-01	
3.63"	± 0.1	3.58"	✓		VERN TH-01	
3.65"	± 0.1	3.72"	✓		VERN TH-01	
3.37"	± 0.1	3.43"	✓		VERN TH-01	

Measured by: <i>DL</i>	Date: 11/08/09
Audited by: <i>JB</i>	Date: 11/08/09
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
B	10.04.14	Added preliminary approval	KJ	

10.04.14

Daryl Leger

From: Harvey Siemens <hsiemens@dartaero.com>
Sent: Tuesday, August 09, 2011 10:33 AM
To: Daryl Leger
Subject: D4334

Daryl

It is acceptable for the tolerances of D4334-5/-7 fairings to be 1 decimal place.

Regards,

Harvey Siemens

Mechanical Designer
DART Aerospace Ltd.

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